



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2055
Job Sheet 168311



Part No: D2055

Job Qty: 5 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/21/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D IPP C 02.03.07 Now turned in house NG IPP REV:D NOW ON DOOSAN 10-02-01 JLM
VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/20/17	11/20/17	0.00	0.00	Start Up Machining		17/12/07
100	Doosan	5 pcs	11/20/17	11/20/17	0.00	1.00	Doosan		17/12/07
110	QC	5 pcs	11/20/17	11/20/17	0.00	0.00	QC2		17/12/07
120	QC	5 pcs	11/20/17	11/20/17	0.00	0.00	QC8		17/12/11
150	HandFinish	5 pcs	11/21/17	11/21/17	0.00	0.09	HandFinish1		18-1-12
160	Outsource	5 pcs	11/21/17	11/21/17			ATG001-VC		18-1-12
170	Packaging	5 pcs	11/21/17	11/21/17	0.00	0.00	Packaging2		
175	QC	5 pcs	11/21/17	11/21/17	0.00	0.00	QC6		
180	Packaging	5 pcs	11/21/17	11/21/17	0.00	0.00	Packaging3		19-01-17
190	QC21-SA	5 Ea	11/21/17	11/21/17	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FA203 deburr all sharp edges as per dwg

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

~~150 - Chemical Conversion Coat per QSI005 4.1~~

160 - ISSUE P/O: BLACK ANODIZE ATG 11/21/17

170 - Receive & Inspect for Damage & Mat'l Certs

175 - QC6- All purchased or subcontracted products

180 - LOCATION : GA

190 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6R1.000	1	50	0	0

Part Specifications

Specifications could not be found.

Plex 12/7/17 9:26 AM Dart.Gagnon.Michelle

DART
AEROSPACE
S018488



Clamp

PART NO: D2055
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/07/17

Job No: 168311

DART
AEROSPACE
S018488



Clamp

PART NO: D2055
Revision:
Operation: Outsource
Change No:

Mfg Date: 12/07/17

Job No: 168311

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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1270 Aberdeen Street
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100	Doosan	5 pcs		11/20/17	0.00	1.00	Doosan		
110	QC	5 pcs		11/20/17	0.00	0.00	QC2		
120	QC	5 pcs		11/20/17	0.00	0.00	QC8		
150	HandFinish	5 pcs		11/21/17	0.00	0.09	HandFinish1		
160	Outsource	5 pcs		11/21/17			ATG001-VC		
170	Packaging	5 pcs		11/21/17	0.00	0.00	Packaging2		
175	QC	5 pcs		11/21/17	0.00	0.00	QC6		
180	Packaging	5 pcs		11/21/17	0.00	0.00	Packaging3		
190	QC21-SA	5 Ea		11/21/17	0.00	0.00	QC21		

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Job Allocations

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Part Specifications

Specifications could not be found.

Plex 11/14/17 8:03 AM dart.boucher.sylvie

Revised. material added

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____

Date: _____

Work Order update only ☐

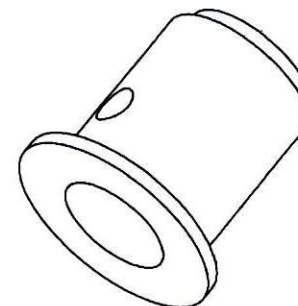
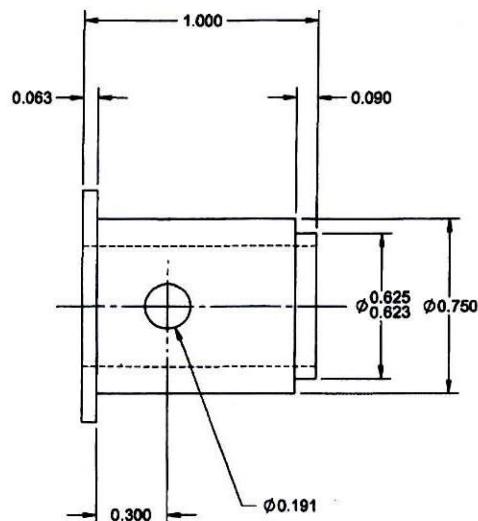
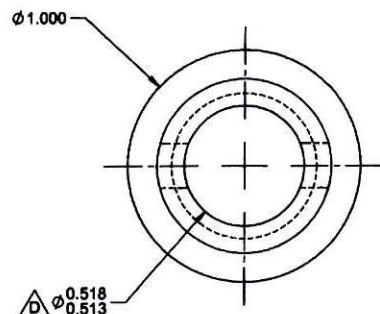
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 168311

DAS
30
9-89

NOV 16 2017



D2055 CLAMP

RELEASED
2013-02-12



NOTES:

- 1) MATERIAL: ALUMINUM, 6061-T6/T651/T6510/T6511/T62 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6R
- 2) FINISH: BLACK ANODIZE PER MIL-A-8625F, TYPE II, CLASS 2 (PREFERRED) OR CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "BLACK SANDING" (4.3.5.7) PER DART QSI 005 4.3 (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

REV.	DESCRIPTION	BY	DATE
D	UPDATE TO CURRENT STANDARDS; BLACK ANODIZE IS NOW THE PREFERRED FINISH, REF PAR12-229; MODIFY HOLE SIZE; ADD POWDER COAT OPTION	SFM	12.12.21
C	ADDED 0.750 O.D. DIMENSION	CP	08.12.10
B	0.191 DIA WAS 0.187 DIA (STR A1100)	CP	08.10.15
A	NEW ISSUE		92.03.13
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SFM		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2055	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	12.12.21	COPYRIGHT © 1983 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038682

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			is required							
20	167949	SWA10A-700	Wire Clamp : IPP Rev A 17.11.08 New issue DP Verify DD -Issue P/O to ATG: -HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 3 CLASS 2 -Certificate of Conformity is required	Firmed	1/17/18	20 pcs	0 pcs	20 pcs	\$7.75/pcs	\$155.00
21	168311	D2055	Clamp Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2 C OF C IS REQUIRED	Firmed	1/17/18	5 pcs	0 pcs	5 pcs	\$6.20/pcs	\$31.00
22	168312	D2056	Bell Crank Assembly ISSUE P/O: BLACK ANODIZE	Firmed	1/17/18	5 pcs	0 pcs	5 pcs	\$6.20/pcs	\$31.00
23	168040	D1038-58B	Avionics Fastener Rail Issue P/O: Black Anodize as per Dwg D1038	Firmed	1/17/18	50 pcs	0 pcs	50 pcs	\$4.25/pcs	\$212.50
24	169062	RBW109-3101-58-1-7	Handle -Issue P/O to ATG: -ANODIZE COLOR BLUE, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	1/17/18	1 pcs	0 pcs	1 pcs	\$51.00/pcs	\$51.00
25	169518	RBW109-3101-58-2-7	Handle -Issue P/O to ATG: -ANODIZE COLOR BLUE, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	1/17/18	1 pcs	0 pcs	1 pcs	\$51.00/pcs	\$51.00
26	168827	RBW6705G02431-3G-1	Lever Rigging Fork -Issue P/O to ATG: - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2	Firmed	1/17/18	3 pcs	0 pcs	3 pcs	\$6.20/pcs	\$18.60



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914404

Date: 11-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

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Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
3 ea	Part: RB910-0003-1 Quill Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22206		Rev: 5 PO: PO038682 Line: 18
6 ea	Part: RBD29936 Tail Rotor Bungee Tool Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22207		Rev: PO: PO038682 Line: 19
5 ea	Part: D2055 Clamp Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils). Job: 22209		Rev: D PO: PO038682 Line: 21
1 ea	Part: RBW109-3101-58-2-3 Hammer Head Clear Anodize per MIL-A-8625F, Type II, Class 1, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22218		Rev: 3 PO: PO038682 Line: 30
3 ea	Part: RBT102103-5 Retainer Clear Anodize per MIL-A-8625F, Type II, Class 1, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22219		Rev: C PO: PO038682 Line: 31
2 ea	Part: RBT102103-3 Adapter Clear Anodize per MIL-A-8625F, Type II, Class 1, .0004-.0010" (.4 - 1 mils), Water		Rev: C Made in Canada.

DAI
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A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914404

Date: 11-Jan-18

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Hawkesbury, ON K6A 1K7

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Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Sealant Job: 22221	PO: PO038682	Line: 33
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>11/2/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D2055 Revision: Clamp														
190	QC21-SA	S018488	168311	5 Ea	0	S018488	GA		Stock	12/7/2017	Issue Container			
Operation Totals:		1		5	0									
Part Totals:		1		5	0									
Part Number: M6061T6R1.000 Revision: Round Bar 1.00"														
100	Receive Ft	S018486	168311	0 ft	0		Start Up Machining		Stock	12/7/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		5	0									

Plex 1/18/2018 9:22 AM dart.Gagnon.Michelle